

Work Order ID 74529



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Tuesday, October 04, 2011 8:18:48 AM

Item ID:	D3794-1	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Gasket					
Start Date:	9/30/2011	Start Qty:	12.00	Cust Item ID:		
Required Date:	10/14/2011	Req'd Qty:	12.00	Customer:		
Reference:						

Approvals:	Process Plan:	<u>M.L.J.</u>	Date:	<u>11/10/04</u>	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3794	Rev A								

100		0.00							
	FLOW WATER JET								
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg D3794 <input type="checkbox"/> Dwg Rev: <u>A</u> <input type="checkbox"/> Prog Rev: <u>A</u> <input type="checkbox"/> 2- Deburr if necessary								

B11-10-11 (14)

110		0.00							
	QC2- Inspect parts off machine FAI/FAIB								
QC	Memo	0.00							
Quality Control									

B11-10-11

120		0.00							
	QC8- Inspect parts - second check								
QC	Memo	0.00							
Quality Control									

Sunolu (14)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 74529

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Tuesday, October 04, 2011 8:18:48 AM

Item ID: D3794-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Gasket

Start Date: 9/30/2011 Start Qty: 12.00



Cust Item ID:

Required Date: 10/14/2011 Req'd Qty: 12.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: <i>FP</i>	0.00							
	Packaging								
	Memo	0.00							
	Packaging								
140	QC21 - Final Inspection - Work Order Release	0.00							
	QC								
	Memo	0.00							
	Quality Control								

10/10/12 *(14)**11/10/12*
MF 11-10-12

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Picklist Print

Tuesday, October 04, 2011 8:18:54 AM

Page 1

Work Order ID: 74529



Parent Item: D3794-1



Parent Item Name: Gasket

Start Date: 9/30/2011

Required Date: 10/14/2011

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP Rev:A 08-05-13 new issue DD verified by:EC
IPP Rev:B 08-05-23 revA as per dwg DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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MNEO60S.063 Purchased No 100 sf 636.8500 0.5902 7.869333 8.5



B11-1041

NEOPRENE SHEET 0.063

Location	Loc Qty	Loc Code
MAT052	636.85	
117295	55.68	
118026	127.87	
118663	73.3	
119130	380	

118663

14

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	74529
Description: Gasket		Part Number:	D3794-1
Inspection Dwg: D3794 Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.19	+0.005/-0.001	.191	✓		V BUZ	
0.300 x 0.300	+/-0.010	306 x 301	✓		V	
1.88	+/-0.030	1.884	✓		V	
0.90	+/-0.030	.90	✓		V	
3.90	+/-0.030	3.90	✓		V	
8.00	+/-0.030	8.00	✓		T BU1	
14.00	+/-0.030	14.00	✓		T	
20.00	+/-0.030	20.00	✓		T	
14.07	+/-0.030	14.07	✓		T	
18.98	+/-0.030	18.98	✓		T	
23.90	+/-0.030	23.90	✓		T	
27.40	+/-0.030	27.40	✓		T	
29.40	+/-0.030	29.40	✓		T	
32.90	+/-0.030	32.90	✓		T	

Measured by:	RB	Audited by:	J	Prototype Approval:	N/A
Date:	11-10-11	Date:	11/10/11	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.05.28	New Issue	KJ/DD	DA

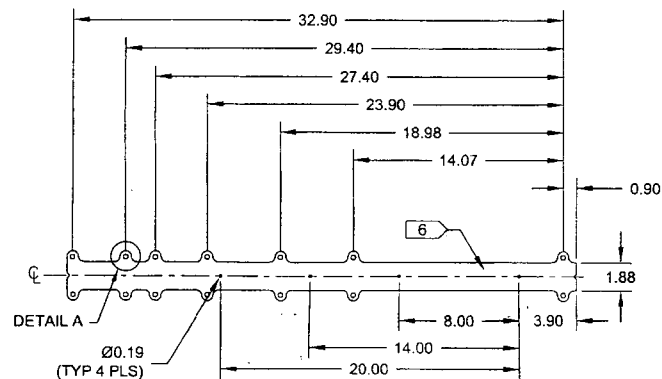
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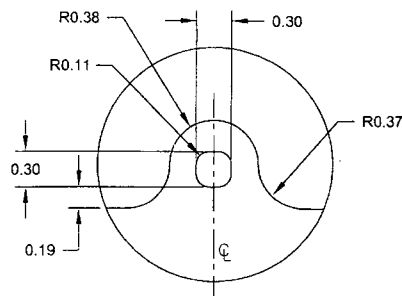
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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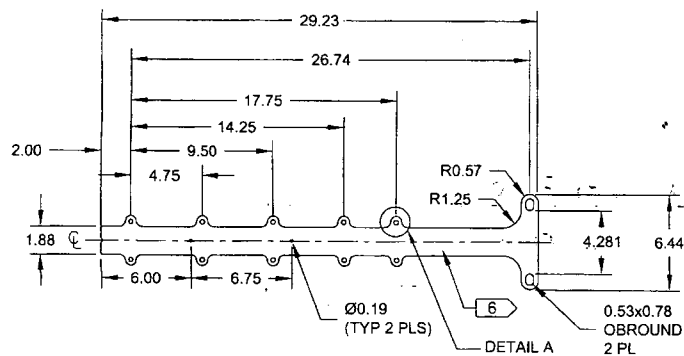
NOTE: Date & initial all entries



D3794-1 GASKET



DETAIL A
SCALE 8X



D3794-3 GASKET

NOTES:

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "DXXXX-X" USING WHITE FINE POINT PERMANENT INK MARKER OR LABEL
- 7) WEIGHT: D3794-1 - 0.23 LBS, D3794-3 - 0.22 LBS

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 74529 M.C.J
11/10/04

RELEASED
08-05-14

A	NEW ISSUE		PH	08.05.14
REV.	DESCRIPTION		BY	DATE
DESIGN	PH	DART AEROSPACE USA, INC PORT HADLOCK, WA		
DRAWN	PH			
CHECKED	PH	DRAWING NO.		REV. A
MFG. APPR.	PH	D3794		SHEET 1 OF 1
APPROVED	PH	TITLE		SCALE
DE APPR.	PH	GASKET		NTS
DATE	08.05.14	COPYRIGHT © 2008 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE, OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.		

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